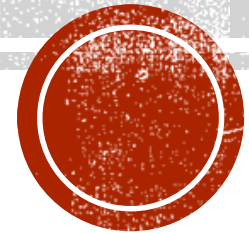




# CONTINUING ISSUES IN THE FIELD



*Randall D. Hand*  
*Training Coordinator*  
*Alabama Public Service Commission*

**NOTICE OF CONSTRUCTION**

Operator Name:			
District:			
Notification Date:			
Contact:		Phone:	
Construction Location: <small>Provide Closest Intersection to Start Location OR Valid Address</small>			
ANTICIPATED START DATE:			
<b>Check or Fill Each Box that Applies</b>			
Construction Performed By:		Operator: <input type="checkbox"/>	Contractor: <input type="checkbox"/>
Contractor Name:			
Pipe Material:	Steel: <input type="checkbox"/>	P.E.: <input type="checkbox"/>	
Type of Construction:	Extension: <input type="checkbox"/>	Relocation: <input type="checkbox"/>	Replacement <input type="checkbox"/>
<b>Pipe Specifications</b>			
Project Length :		O.D:	
Wall:	<small>(in)</small> SDR:: <small>(P.E. only)</small>	SMYS: <small>(other units)</small>	
MAOP: <small>(in)</small>	Test Pressure: <small>(in)</small>	Air: <input type="checkbox"/>	Water: <input type="checkbox"/>
Distribution: <input type="checkbox"/>		Transmission: <input type="checkbox"/>	

**DIG SAFELY, CALL FOR A LINE LOCATE 48 HOURS BEFORE EXCAVATING!**

PLEASE SUBMIT THIS NOTICE 2 WEEKS PRIOR TO CONSTRUCTION:

RETURN TO:  
 ALABAMA PUBLIC SERVICE COMMISSION  
 GAS PIPELINE SAFETY  
 P O BOX 304260  
 MONTGOMERY, AL 36130-4260  
 OR  
 FAX (334)242-0687  
 OR  
 Email: [felisa.webster@psc.alabama.gov](mailto:felisa.webster@psc.alabama.gov)

*This form was generated in an effort to comply with APSC Gas Pipeline Safety Rule No. 6: "All construction work involving the addition and/or replacement of gas pipelines or mains greater than 1,000 feet in length shall be reported to the APSC before construction begins."*

# NOTICE OF CONSTRUCTION FORM

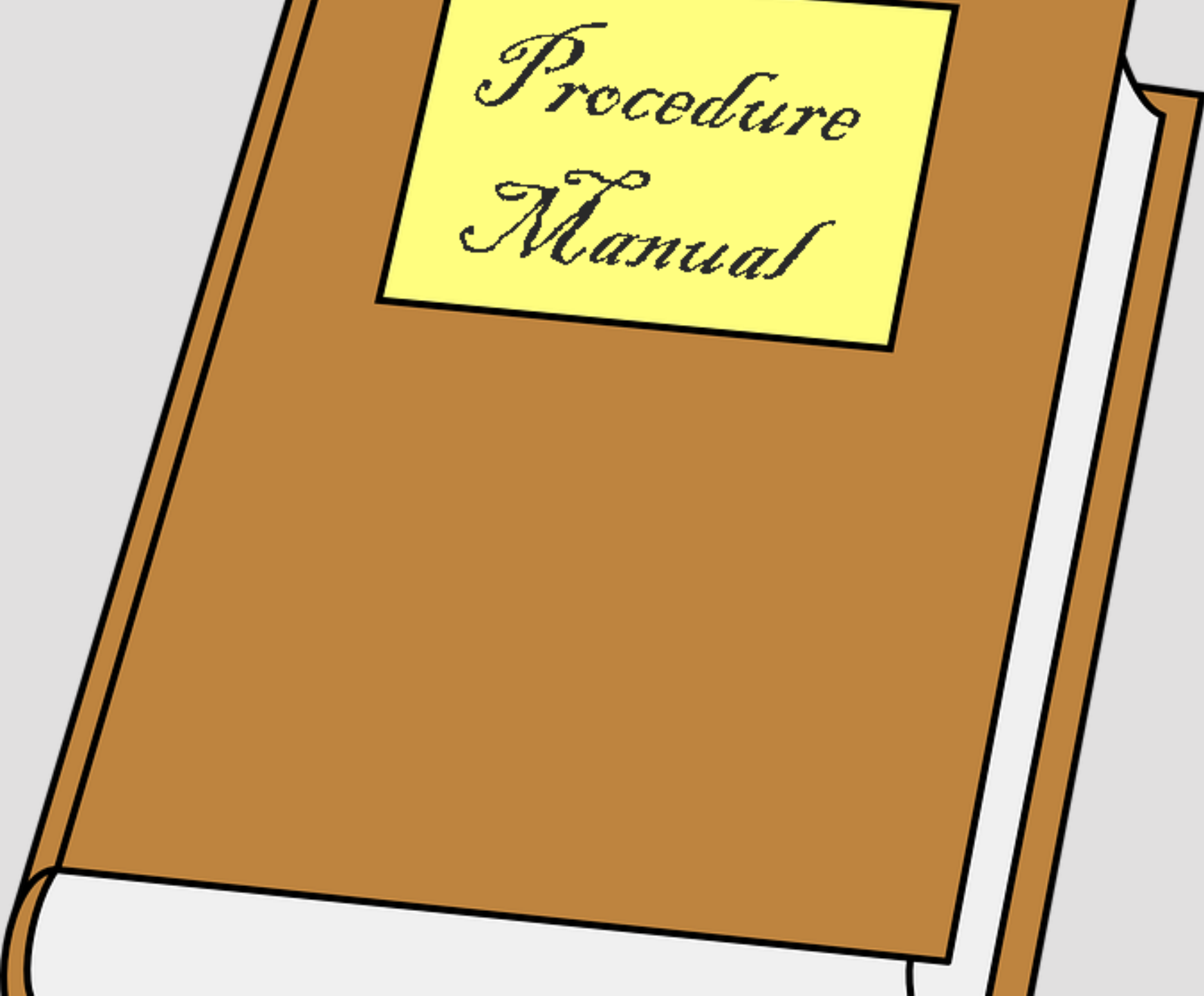
Notification of any pipe being installed, 1000 ft or more this includes mains and services.

Must be made prior to starting project.

Must contain a valid address or street intersection.

Include the County in the District space on the form.





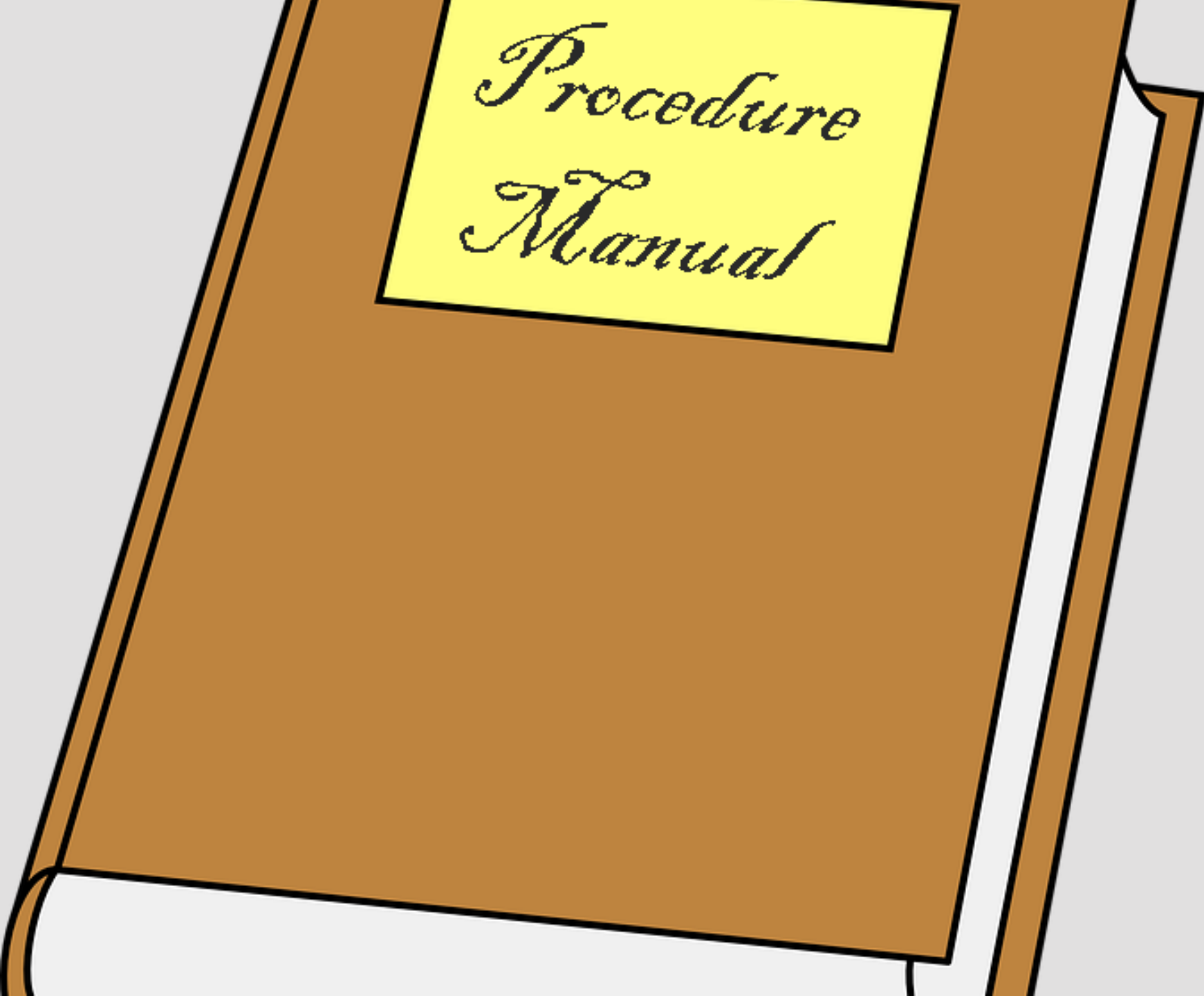
# *Procedure Manual*

## **PROCEDURES**

Procedures must be on the job site for the task being performed

192.605 (a) ... appropriate parts of the manual must be kept at location where operations and maintenance activities are conducted.





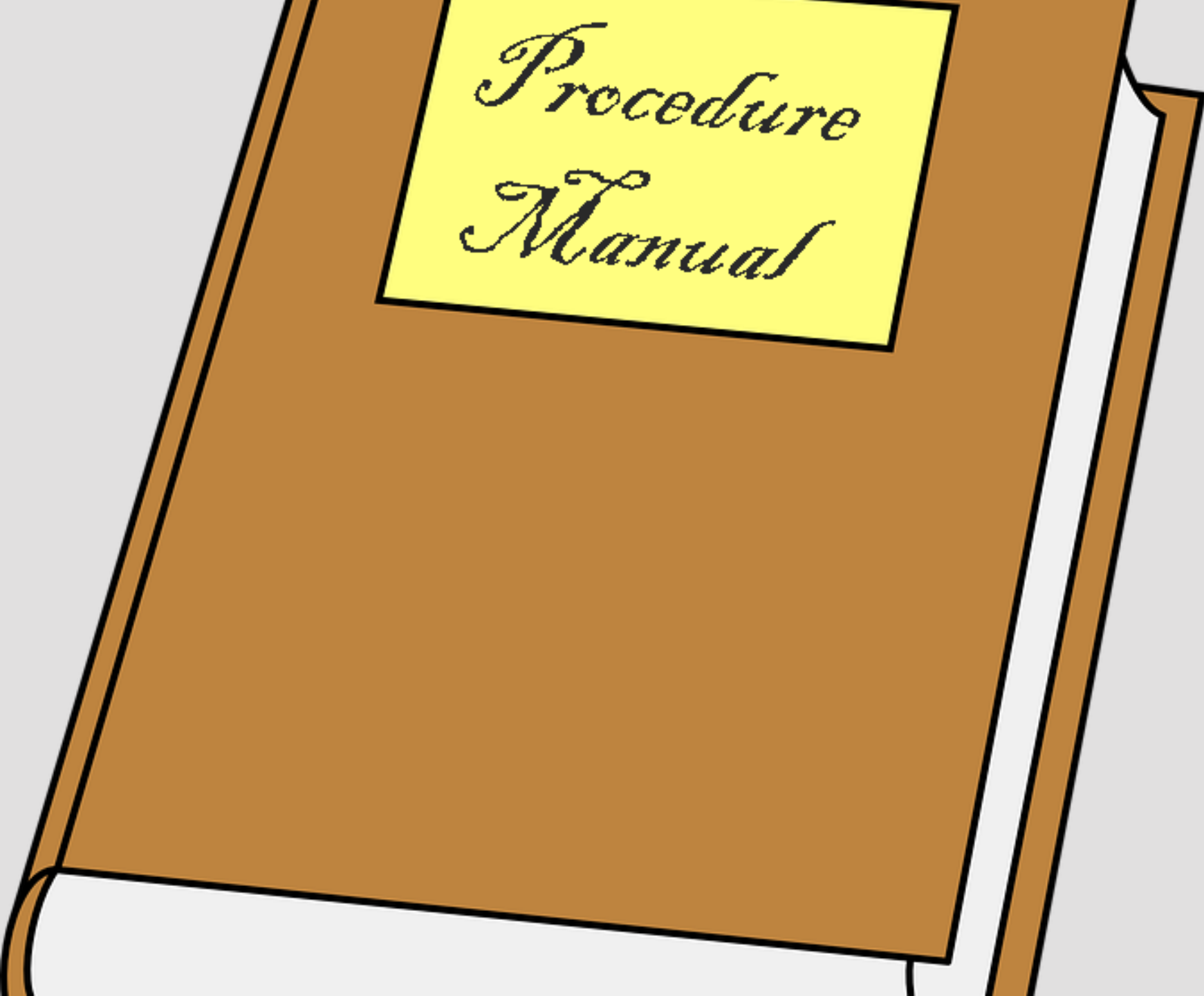
# *Procedure Manual*

## **PROCEDURES**

Manual can be web based/ cloud based etc.

If it is kept electronically, you must know how to access it. You can have written instructions to “walk” you through the process, but you can not call “the office” and get them to help you. This is not acceptable you must be able to access it on your own in the field.





# *Procedure Manual*

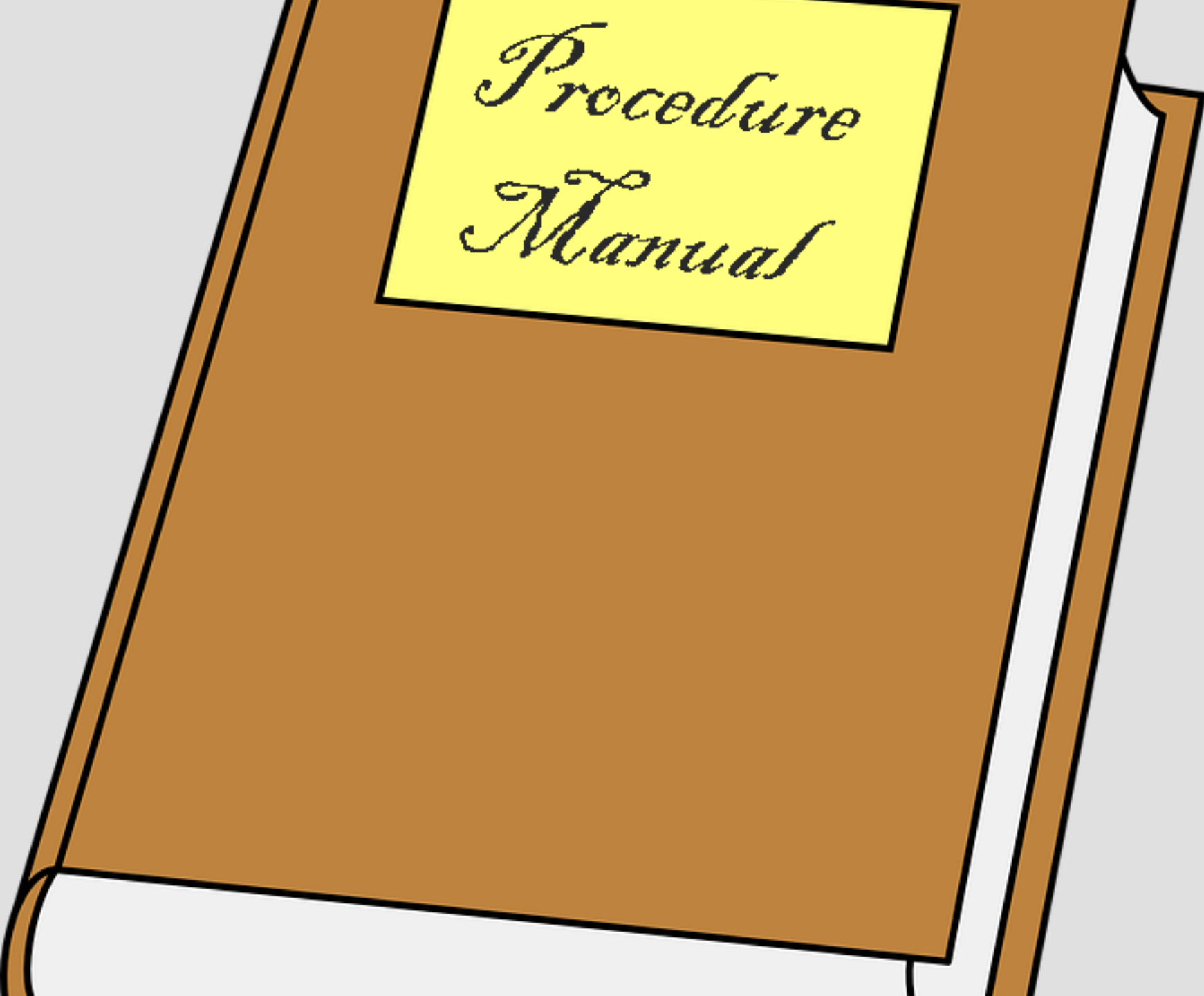
## **PROCEDURES**

Procedures in the manual that are being performed must be followed as they are written.

If procedure is not being followed as written, it can result in a violation .

Can not skip a section because “it doesn’t work that way” or “we don’t do it that way”





# *Procedure Manual*

## **PROCEDURES**

If procedures are found to be irrelevant , incorrect, outdated etc.

Let someone know!

There is a process to change them and it is not complicated.



# PROOF OF QUALIFICATION

Qualification proof  
should be kept on the job  
site. Each individual  
performing a covered  
task must have proof of  
qualification for that task.

**GAS OPERATIONS AND CONSTRUCTION ASSIGNED TASK:**  
Gas Operations and Construction Assigned Tasks:  
Abandoning of Service - Lines and Mains Conducting Gas Leakage Surveys • Corrosion Control -  
Applying Pipe Coating in the Field as part of Maintenance Corrosion Control - Checking/Replacing  
Electrical Isolation Couplings on Existing Pipelines Corrosion Control - Cleaning and Coating Pipe for  
Atmospheric Corrosion  
Corrosion Control - Clearing a Shorted Casing Corrosion Control - Conducting a Soil Resistivity Survey  
Corrosion Control - Inspecting for Atmospheric Corrosion Control - Inspecting the Condition of Exposed  
Coatings and Rechecking after Clearing a Short Corrosion Control - Inspecting the Condition of Existing Pipeline  
Pipe or Pipe Coating Corrosion Control - Installation/Replacement of an Anode on an Existing Pipeline  
Corrosion Control - Installation/Replacement of Protection Rectifier on an Existing Pipeline  
Corrosion Control - Installing or Replacing a Corrosion Test Station on Existing Pipeline for Electrical  
Measurement Corrosion Control - Interference Testing Corrosion Control - Measuring Pipe-to-Soil  
Potential Corrosion Control - Visually Inspecting for Internal Corrosion Damage Prevention and  
Excavation Inserting Plastic Pipe into a Casing  
Inspecting and Operating Valves Inspecting/Repairing a Recording Gauge at Pressure Regulator  
Stations  
Investigating Leak and Odor Complaints

**ATOR QUALIFIED**  
**A NATURAL GAS**  
**RANDALL HAND**

**GAS OPERATIONS  
&  
CONSTRUCTION**

**APGA Security and Integrity Foundation**  
Operator Qualification Training & Evaluation  
Certificate of Completion  
Name: Randall Hand  
Date: September 13, 2006  
This Certificate Confirms that the Named Attendee has Successfully  
Completed Training & Evaluation for the ASME B31Q Covered Tasks Listed  
on the Back of this Card.  
For Verification of Completion or Questions Regarding  
Qualification Please Call (202)370-6211  
Bert Kalisch—President/CEO  
APGA Security and Integrity Foundation



# PROOF OF QUALIFICATION

Qualification proof  
should have the task that  
the individual is covered  
to perform

Date that Qualification  
was obtained and  
requalification date.

**GAS OPERATIONS AND CONSTRUCTION ASSIGNED TASK:**  
Gas Operations and Construction Assigned Tasks:  
Abandoning of Service - Lines and Mains Conducting Gas Leakage Surveys • Corrosion Control -  
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Investigating Leak and Odor Complaints

**ATOR QUALIFIED  
A NATURAL GAS**

**RANDALL HAND**

**GAS OPERATIONS  
&  
CONSTRUCTION**

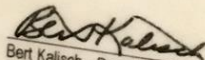
**APGA Security and Integrity Foundation**  
Operator Qualification Training & Evaluation  
Certificate of Completion

Name: Randall Hand

Date: September 13, 2006

This Certificate Confirms that the Named Attendee has Successfully  
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on the Back of this Card.

For Verification of Completion or Questions Regarding  
Qualification Please Call (202)370-6211


  
Bert Kalisch—President/CEO  
APGA Security and Integrity Foundation



# PROOF OF FUSION QUALIFICATION

Proof of qualification for  
**FUSION, MUST BE  
ONSITE WITH THE  
INDIVIDUAL** doing the  
fusing.

Fusion Qualification must  
be done at least once  
every 12 months not to  
exceed 15 months

 **QUALIFICATION OF JOINING POLYETHYLENE**  
**CERTIFIES THAT**  
**PROCEDURE:** IUNV-2708B Randall D. Hand IUNV-2708SA  
IUNV-2708SO IUNV-4710B  
IUNV-4710SA IUNV-4710SO  
ICENTRAL IFRIATEC  
IMTDTRIFUSION

**QUAL. NO: 14344**

**COMPLETED REQUIREMENTS FOR  
QUALIFICATION ON GAS PIPE FOR:**  
PE2708/4710 RESIN PPI VALIDATED

☒ BUTT FUSION ☒ SADDLE FUSION  
☒ SOCKET FUSION ☒ ELECTROFUSION  
☐ MECHANICAL JOINT

**ADMIN, GAS  
PIPELINE  
SAFETY**

**4/7/2017**  
**DATE**

*WRJ*



# PROOF OF FUSION QUALIFICATION

The fusion qualification that the  
PSC provides is **ONLY** good for

**TR-33**

## UNIVERSAL PROCEDURES

If you are using different  
parameters for fusing-

Temperature, Heating Times,  
Bead Size etc.

This card is **NOT** valid.

If you are using parameters  
different than the procedures  
you provide us and you **DO NOT**  
have proof of qualification  
under those procedures.

You may receive a violation and  
all of the fuses that you have  
done may be removed from  
where they were installed.



**QUALIFICATION OF JOINING POLYETHYLENE**  
**CERTIFIES THAT**  
**PROCEDURE:** 1UNV-2708B  
1UNV-2708SO  
1UNV-4710SA  
1CENTRAL  
1MTDTRIFUSION

QUAL. NO: 14344

COMPLETED REQUIREMENTS FOR  
QUALIFICATION ON GAS PIPE FOR:  
PE2708/4710 RESIN PPI VALIDATED

☒ BUTT FUSION ☒ SADDLE FUSION  
☒ SOCKET FUSION ☒ ELECTROFUSION  
☐ MECHANICAL JOINT

4/7/2017  
DATE

ADMIN, GAS  
PIPELINE  
SAFETY

WJ

Randall D. Hand  
1UNV-2708SA  
1UNV-4710B  
1UNV-4710SO  
1FRIATEC

# PROOF OF FUSION QUALIFICATION

Fusion Qualification Proof **MUST**  
Have the Type of Fusion that is  
Covered

EXAMPLE :

Socket Fusion, Sidewall Fusion,  
Butt Fusion ETC.

**IT Is NOT Good For Two Years**

If you are using parameters  
different than the procedures  
you provide us and you **DO NOT**  
have proof of qualification  
under those procedures.

You may receive a violation and  
all of the fuses that you have  
done may be removed from  
where they were installed.

Certificate #20170136

## Fusion Training Certificate

Presented by [redacted] Industries, Inc. for successful completion  
of the butt fusion and socket fusion training procedures according to  
ASTM F 2620 for:

**MMI McElroy Machine # 1LC thru 26 Manual and  
Saddle Fusion Equipment**

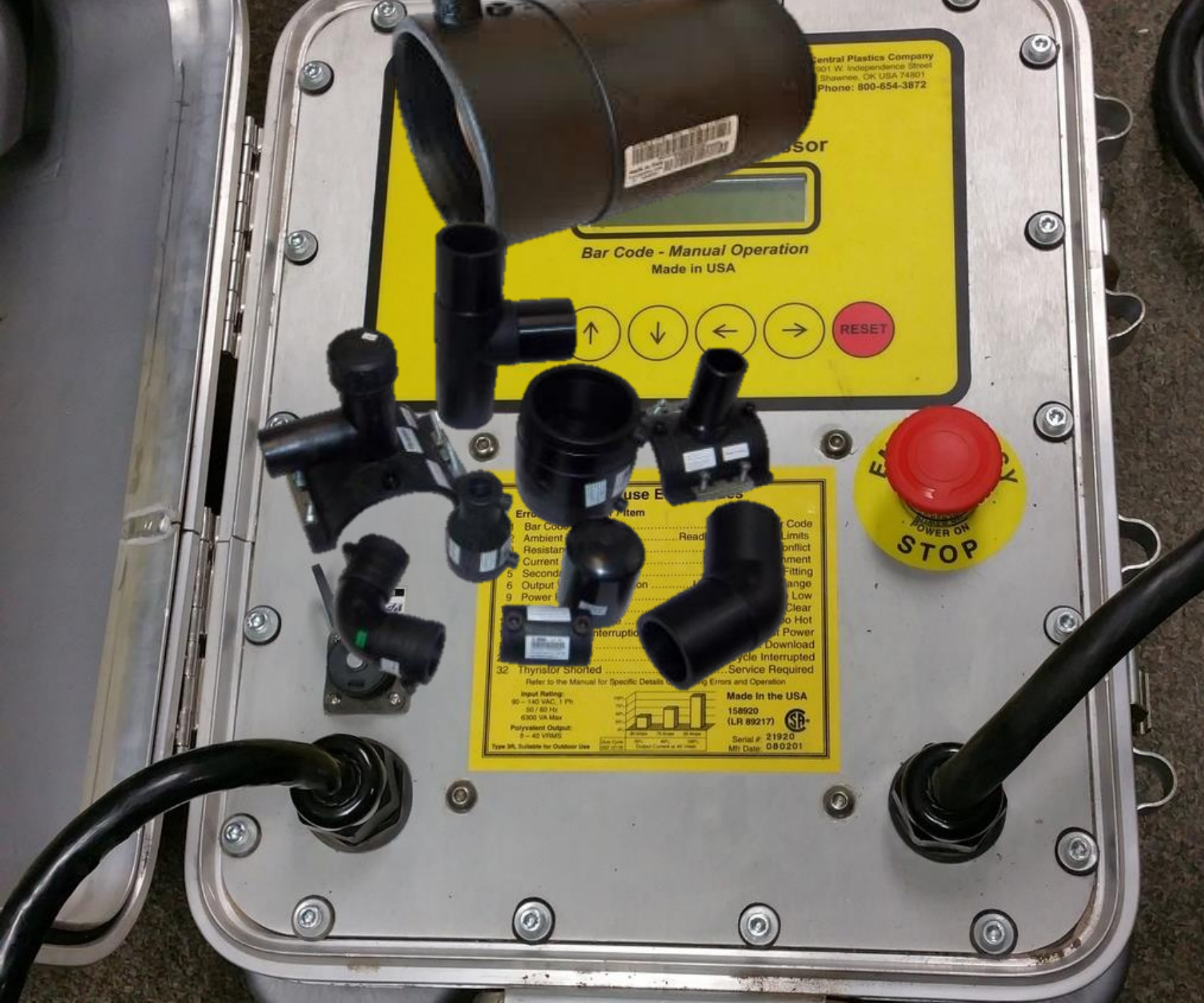
Issued on: 2/10/2017  
Expires on: 2/10/2019

**Awarded to**

Fusion Trainer:

Quality Assurance Trainer



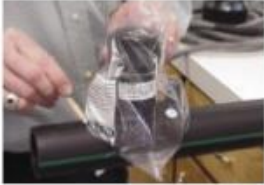


# ELECTROFUSION



## **Electrofusion Joining Procedures for Sidewall/Saddle Fittings** **(for use with under-clamp on 1-1/4" - 6" fitting bases)**

1.) Identify the location of the fitting to be installed on the pipe and mark the area with a non-greasy marker.



2.) Check the pipe surface for any embedded debris that may cause damage to scraping tools making sure that the outer pipe surface is clean and free of any dirt or mud that could recontaminate the scraped pipe surfaces.

3.) Scrape the area to be fused with an approved scraping tool. Make sure that the appropriate amount of material is removed approx. .007" to .0010".

**Do not use abrasives, grinding wheels, or other devices that do not cleanly remove the contaminated material.**

**NOTE: The purpose of scraping is to remove material from the pipe surface. Simply roughing up the fusion area will not allow an acceptable bond to take place. (see "Proper Pipe Preparation" page 3 )**



4.) Avoid touching the scraped pipe surface or the inside of the fitting as body oils and other contaminants can affect fusion joint performance. If the surfaces become contaminated, clean thoroughly with a clean, lint free towel and a **minimum 70%** concentration of isopropyl alcohol and allow to dry before assembling. **Do not use alcohol with any additives other than water.**

### **CAUTION:**

AVOID ALL POSSIBLE RECONTAMINATION OF THE PREPARED SURFACE.

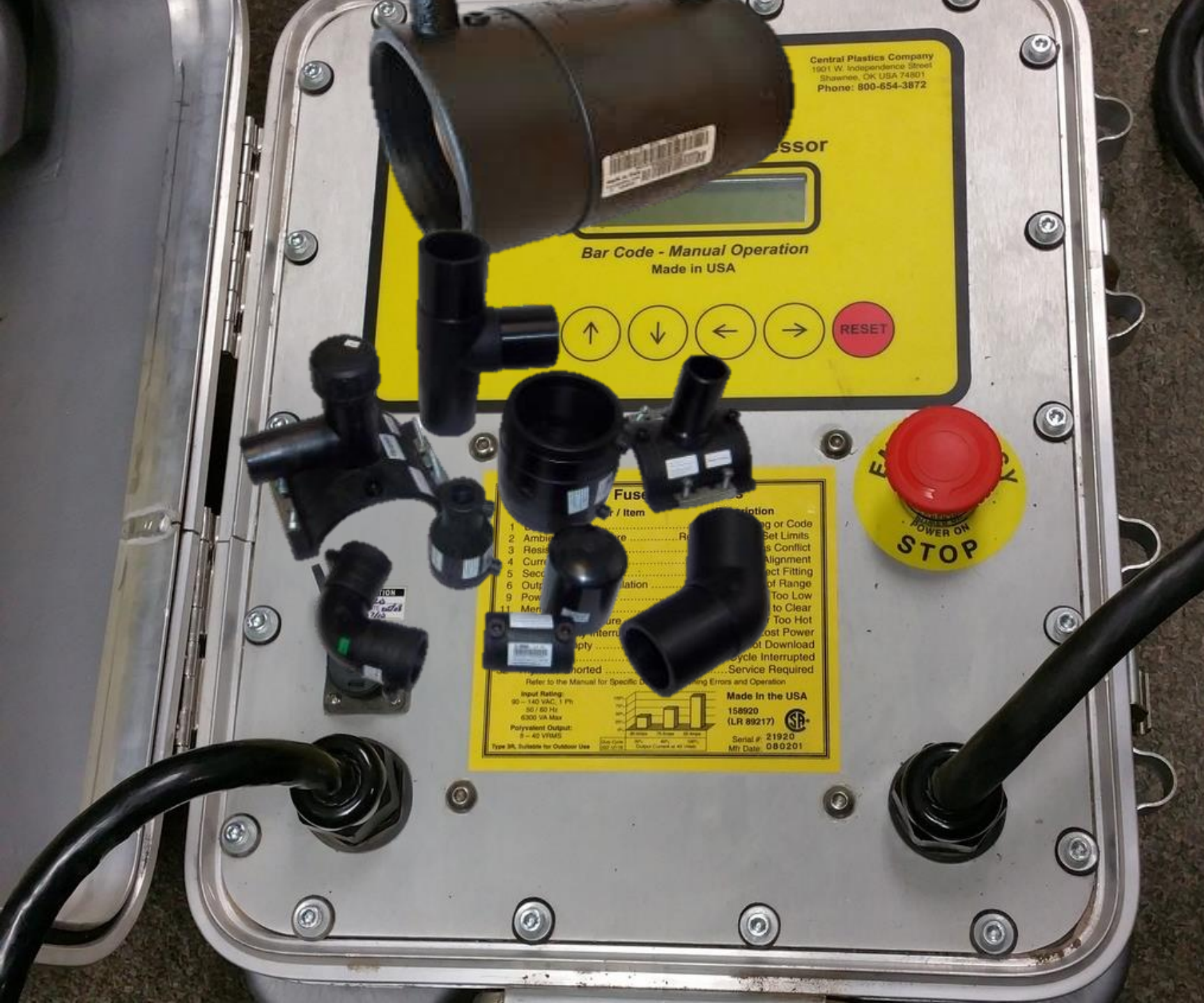
# **ELECTROFUSION**

Procedures are  
"USUALLY" provided with  
the fitting being used.

They are generally on the  
packaging or inside of  
the packaging.

You must follow the  
procedures provided by  
the manufacturer at a  
minimum.

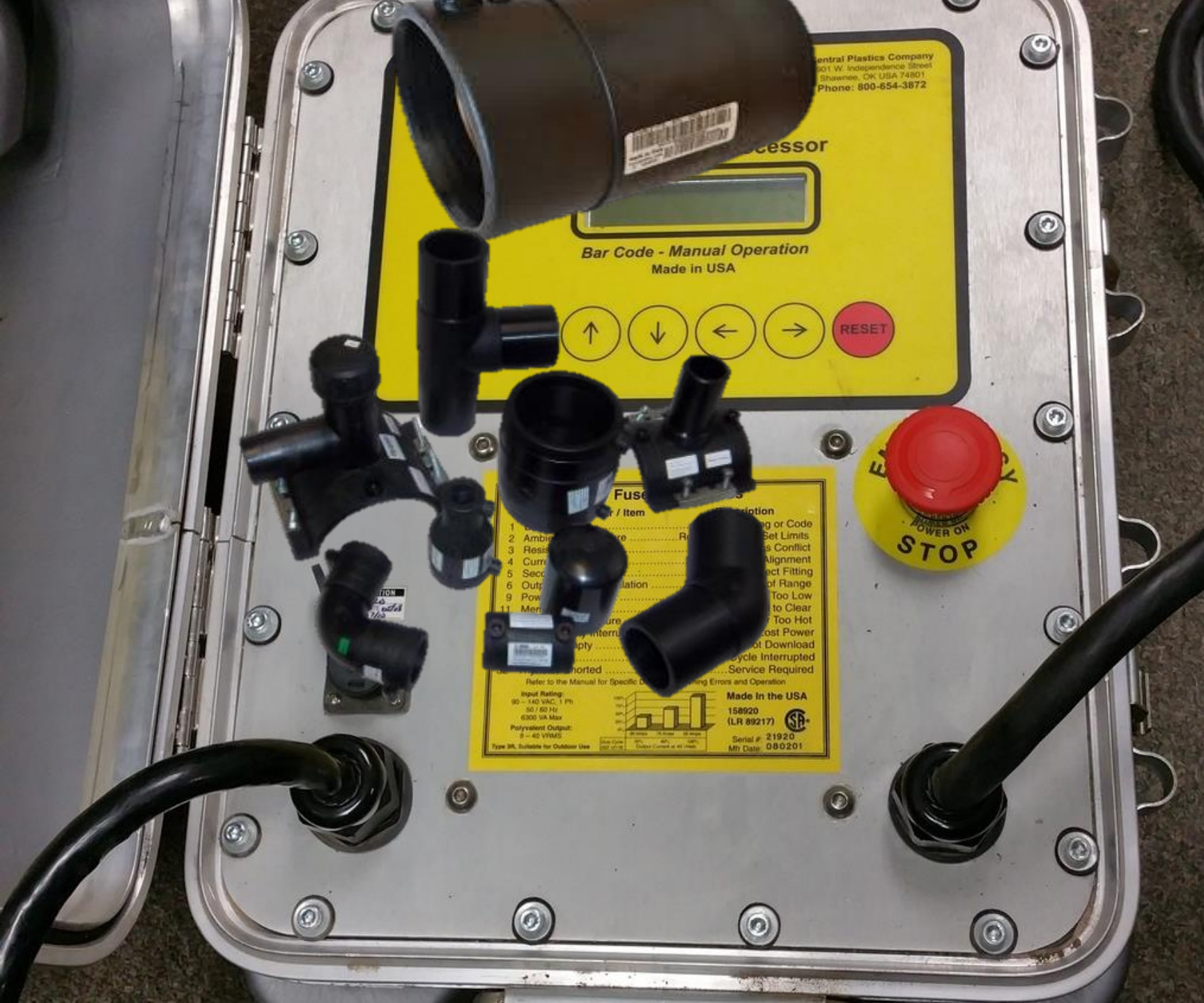




# ELECTROFUSION

Electrofusion Processors must be updated and calibrated in accordance with the manufacturers recommendations.





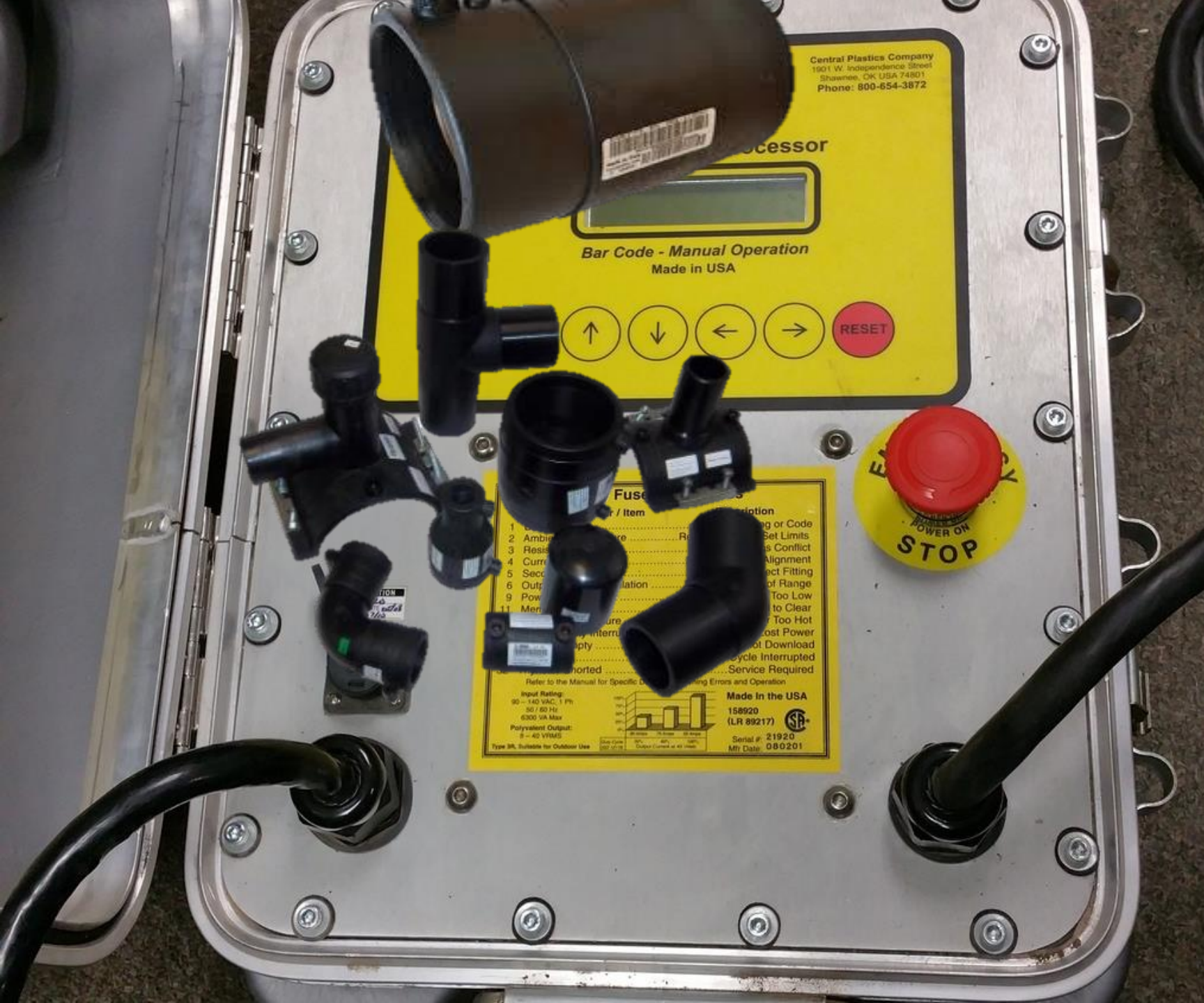
# ELECTROFUSION

The majority of all Electrofusion fitting manufacturers procedures require “THE USE OF AN APPROVED SCRAPER” however the preferred method of pipe preparation is some type of “peeler” style tool.

The approved style of scraper varies with the manufacturer.

You must have a tool that is specified in your procedures.





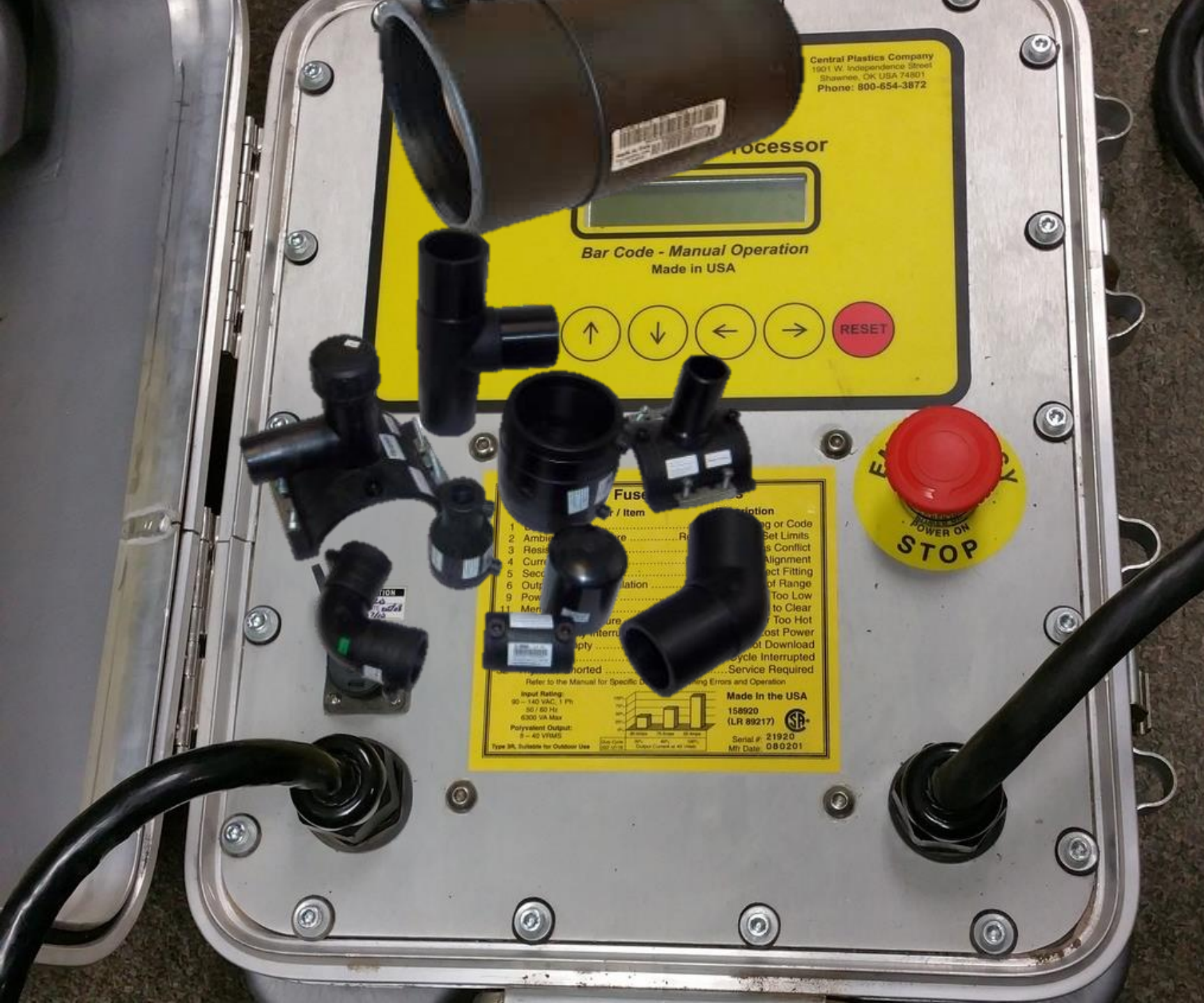
## ELECTROFUSION

Pipe Scraping Tools must be capable of –

Removing the oxidation on the outer surface of the pipe.

Removing the material in a consistent smooth manner.





# ELECTROFUSION

Methods that are  
**NOT** approved-

Abrading Cloth  
(sandpaper)

Razor Blades

“scotch brite pads”

Farriers Rasp

Pocket Knife

Putty Knife





**NOT  
APPROVED  
ELECTROFUSION  
SCRAPING  
TOOLS**



# ELECTROFUSION

- Alcohol Used In the Electrofusion Process **MUST** Be 96% or **GREATER**





## **ELECTROFUSION**

Depth should be marked to insure that pipe/ coupling does not shift during fusion.

Clamping is not required on every size pipe but it is recommended.



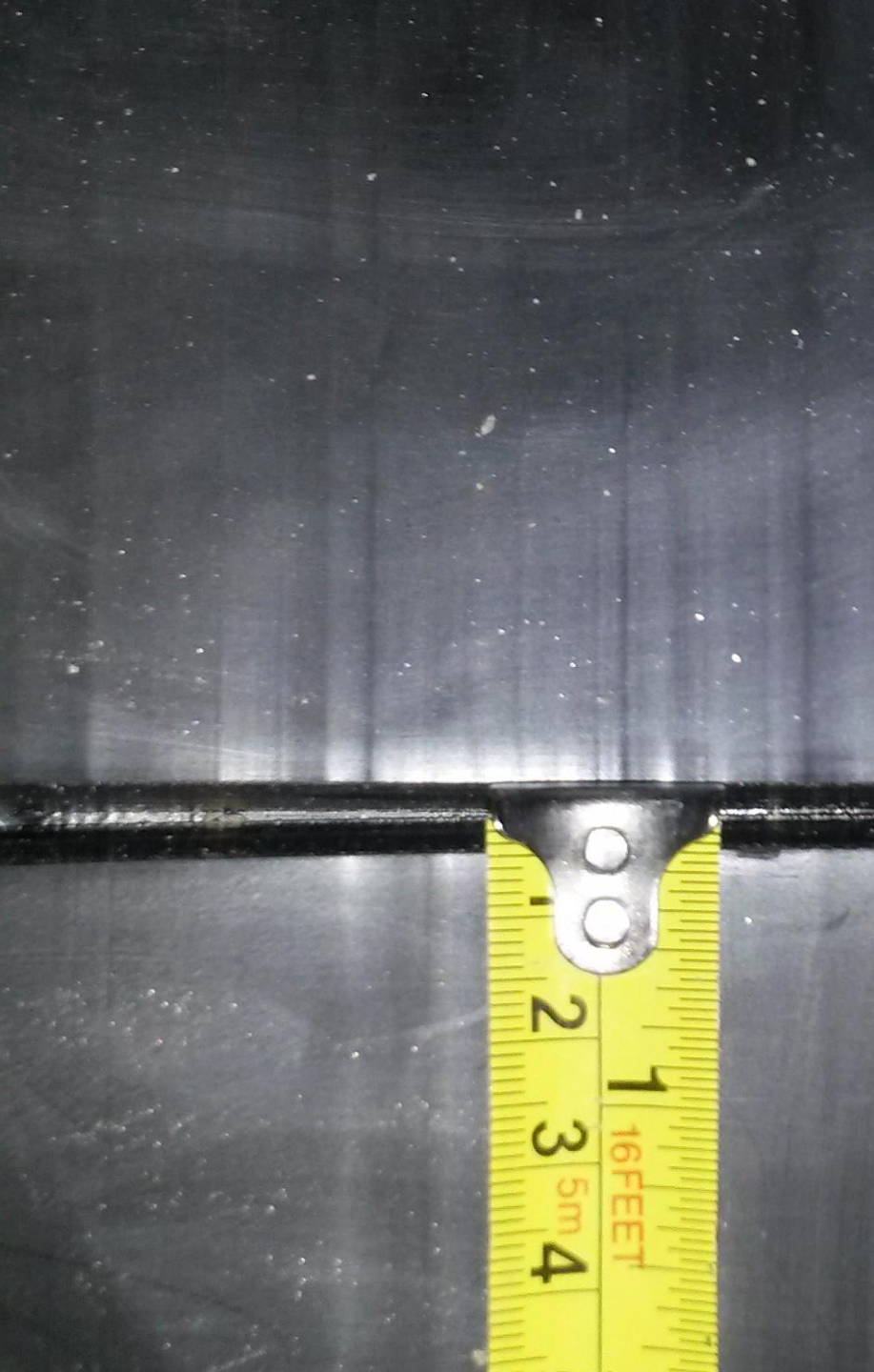


## ELECTROFUSION

Depth should be marked to insure that pipe/ coupling does not shift during fusion.

Clamping is not required on certain sizes of pipe but it is recommended.





## ELECTROFUSION

Depth should be marked to insure that pipe/coupling does not shift during fusion.

Clamping is not required on certain size pipe but it is recommended.





## **ELECTROFUSION**

Fittings Should Be  
Inspected Thoroughly  
Before Use To Ensure That  
Fittings Are Clean and  
Undamaged



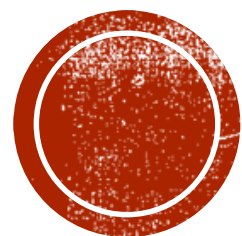
# ELECTROFUSION

- Fittings Should Be Inspected Thoroughly Before Use To Ensure That Fittings Are Clean and Undamaged
- Wires Were Not Coated From The Factory.



# EQUIPMENT MAINTENANCE AND UPKEEP





**EQUIPMENT MUST WORK  
THE WAY IT WAS  
DESIGNED TO WORK**

## EQUIPMENT MAINTENANCE

***All equipment used in the fusion process must be in Proper Working Condition***







# FUSION HEATER PLATES MUST HAVE THE PLATE ON THEM.

**Can NOT use a plate without the  
Teflon Plate**



**Heater MUST have the Teflon plate  
on it**





# UNIVERSAL PROCEDURE POINTERS

Butt Fusion  
Temperature is  
400 to 450 degrees  
**NOT 500 degrees**

Pipe Should be  
aligned properly in  
the cradle.





**PIPE ENDS MUST  
BE ALIGNED  
PROPERLY**





**BEAD SHOULD  
HAVE A DOUBLE  
ROLL BACK**





# **BEAD SHOULD HAVE A DOUBLE ROLL BACK**

Not sure how a single roll  
was accomplished but  
there it is.





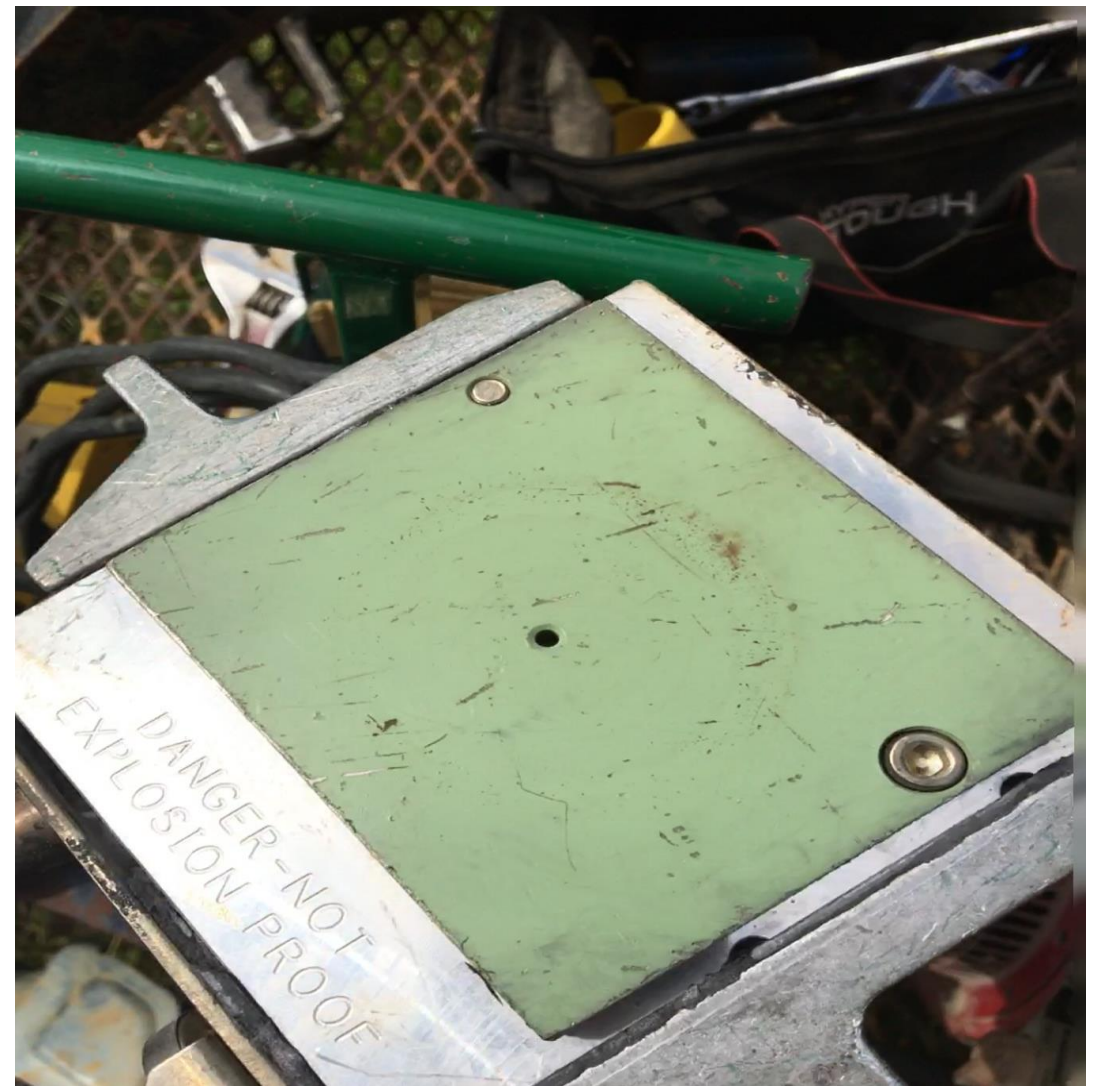
## ***Unacceptable Heater Plate***



## ***Unacceptable Heater Plate***



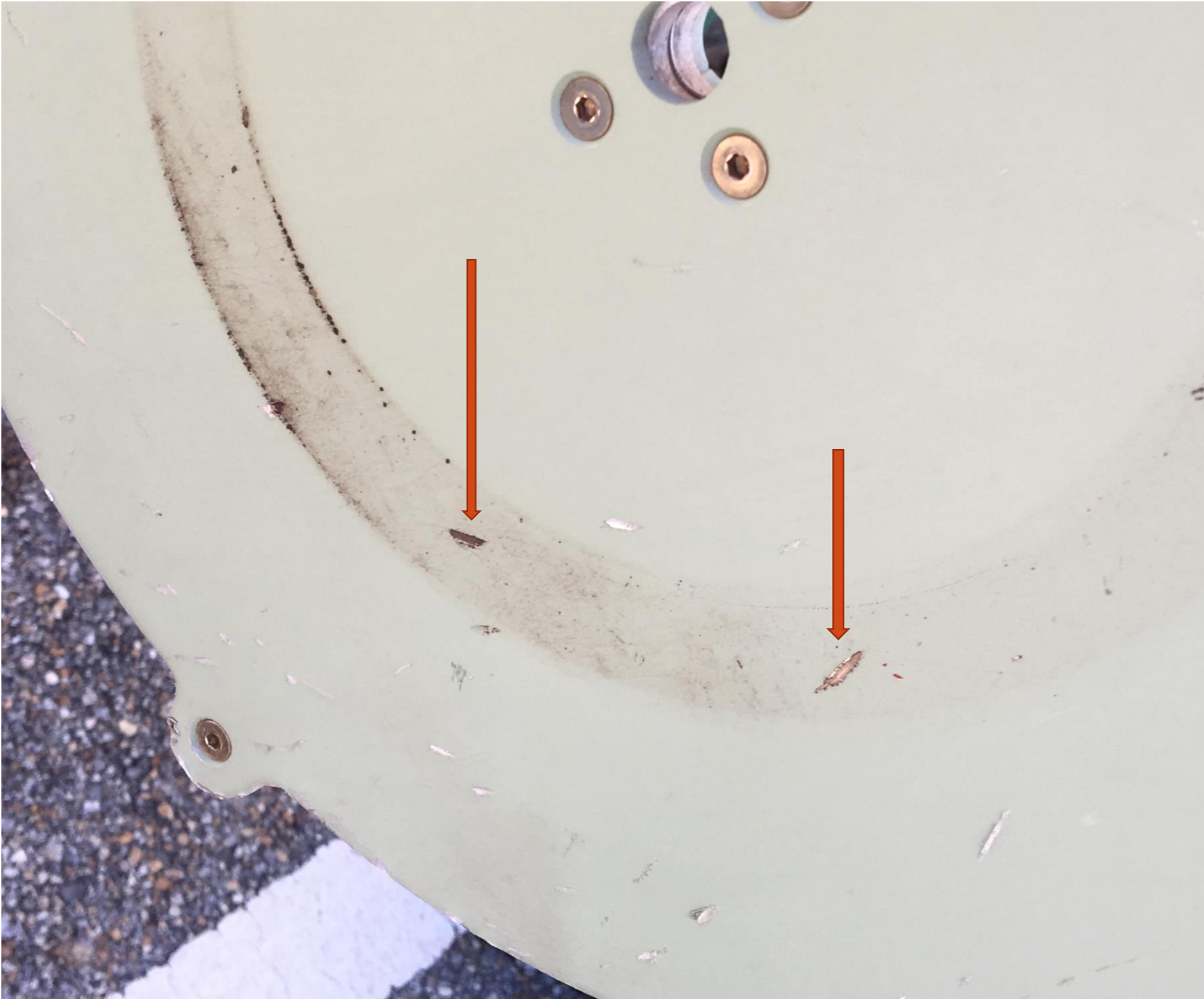
## ***Unacceptable Heater Plate***



# ***Unacceptable Heater Plate***

*Plate not maintained properly*





**REPLACE !!**

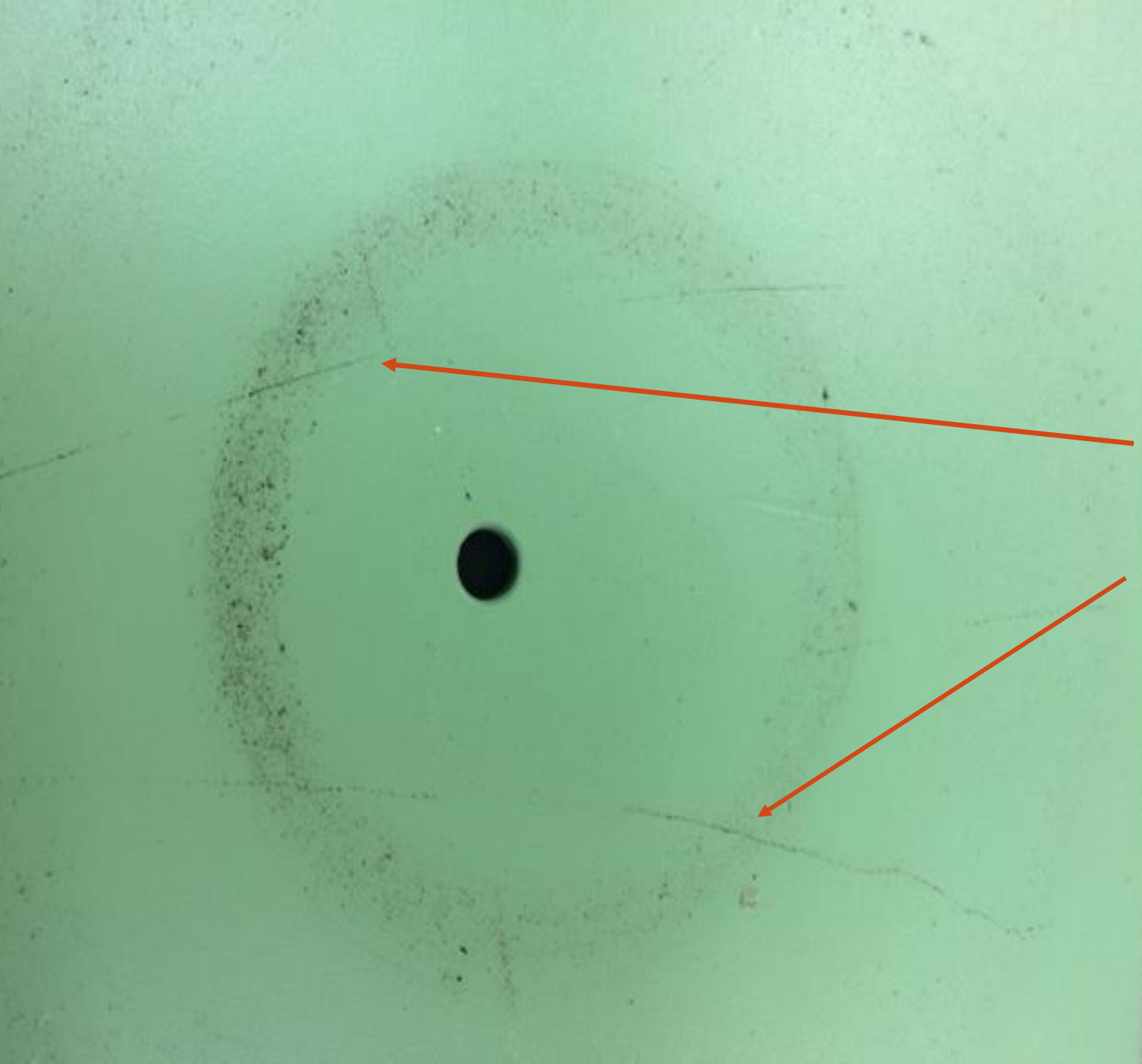
Coating Damaged Inside  
of the Contact Area





***Excessive Ink residue build  
up on heater plate***

The image shows a large industrial machine, likely a flexographic printing press, with a green heater plate. The heater plate is covered in a thick, dark, circular pattern of ink residue, indicating excessive build-up. The machine has a metal frame with various components, including a large metal plate on the left and a smaller metal plate on the right. The background shows a dark, industrial setting with a yellow floor.



*This could be considered acceptable, coating is still intact and not excessively gouged.*



# BUTT FUSION CRADLE

Cradle should move  
freely

Rails should be straight,  
smooth.

Proper Pipe inserts  
should be installed to  
match the size pipe being  
fused.

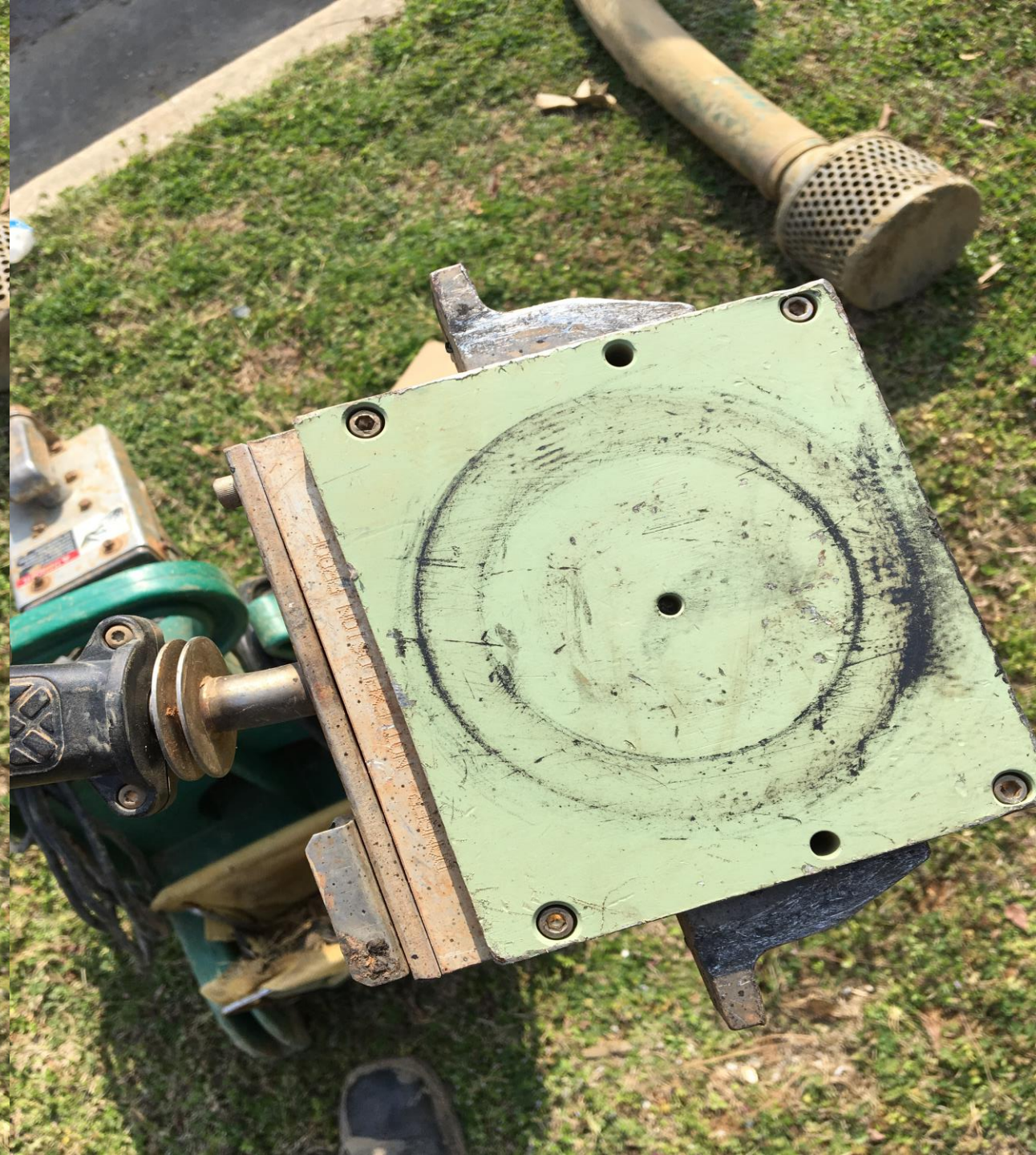




# BUTT FUSION CRADLE

Well Maintained  
Equipment DOES  
NOT look like this.







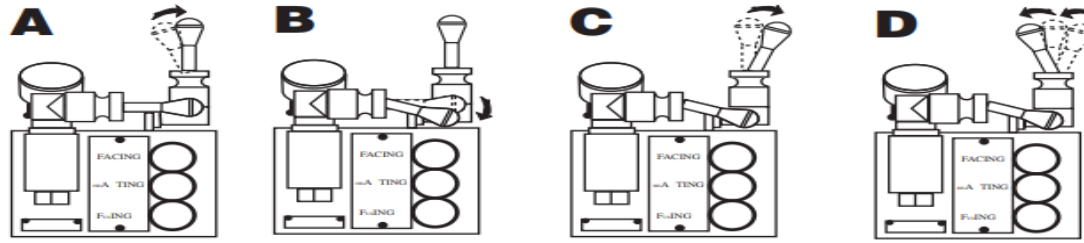
# HYDRAULIC FUSION



## Fusing The Pipe

**CAUTION** Failure to follow the proper shift sequence, verify proper melt pattern and achieve proper cooling time may result in a bad joint.

After proper melt pattern has been established, use the **Approximate Melt Bead Size** chart on page 42 to determine the proper size, then:



A) Shift carriage control valve to neutral position if not in this position already.

B) Shift the selector valve down to fusion position.

C) Move the carriage to the right just enough to remove the heater. The stripper bar on the heater should help “pop” heater loose. Quickly remove the heater without coming into contact with melted pipe ends.

D) Quickly inspect pipe ends, which should be flat, smooth, and completely melted. Concave pipe ends are unacceptable, see page 42. If acceptable, shift carriage control valve to the left immediately bringing ends together and apply fusion pressure, calculated from page 35 or obtained from fusion pressure charts in Reference Section, pages 80-85.

### Notice:

Bring pipe ends together being careful not to exceed the **Approximate Dwell/Transfer Times** shown on page 42.



## Hydraulic Butt Fusion Machine Procedure

# PROCEDURE MUST BE FOLLOWED

ALL bead  
up/heating/ fusion  
pressures/  
Temperatures must  
be followed as  
required by pipe  
manufactures charts





**SPECIFIC MACHINE  
TRAINING SHOULD  
BE PROVIDED  
BEFORE  
PRODUCTION FUSES  
ARE MADE**





**SIDE WALL AND  
SOCKET FUSION  
TEMPERATURE**

**490-510  
degrees**





## **SIDEWALL MACHINE**

Rails should be smooth and clean.

Head unit should travel freely.

Gauge must be on the machine and in **FUNCTIONING** order.  
(probably should at least start out on zero)

Should have the proper pipe inserts for the size pipe being used.







## PIPE MATERIALS MUST BE COMPATIBLE

Older fittings are not  
compatible with newer  
resin pipe





## **PIPE MATERIALS MUST BE COMPATIBLE**

Pipe Preparation is  
Extremely Important.

Alcohol Can NOT be  
used after Pipe Has Been  
Abraded, ONLY BEFORE.





# PIPE MATERIALS MUST BE COMPATIBLE

Fusion/ Heating  
Pressures Must Be  
Followed as Required by  
Fitting Manufacturer.



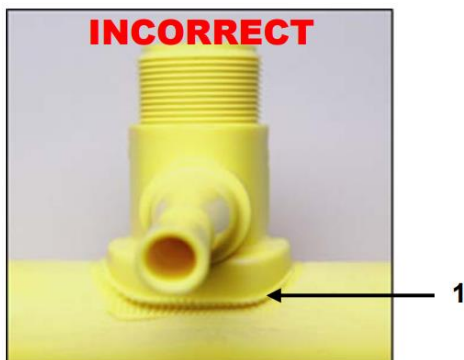


## **PIPE MATERIALS MUST BE COMPATIBLE**

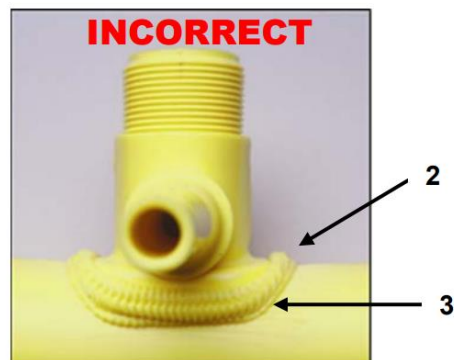
Acceptable Visual  
Appearance of The  
Fusion Bead Melt Pattern  
is Required to Validate  
the Fusion.



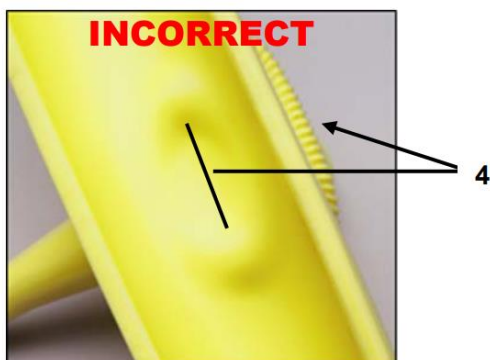
## Unacceptable Fusions



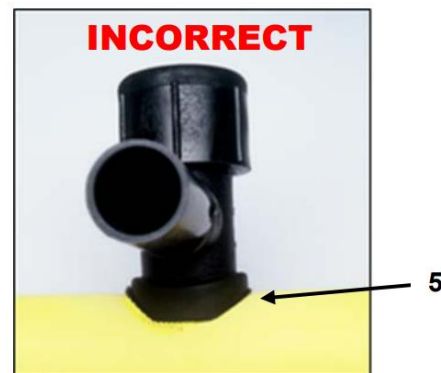
1. Insufficient melt and misaligned



2. Bead above base of fitting  
3. Excessive melt and force



4. Excessive melt and force

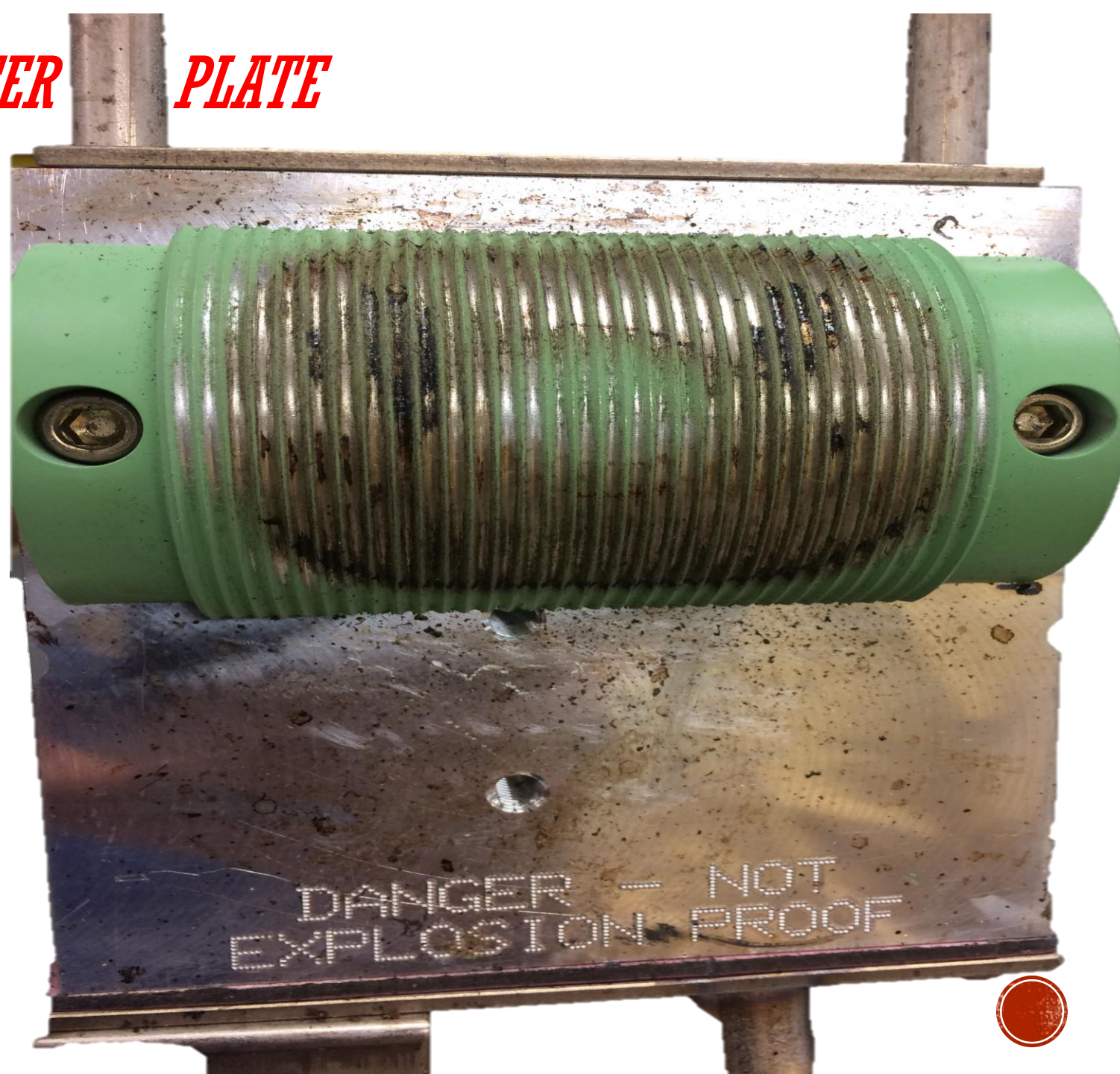


5. Insufficient melt

**IF IT LOOKS BAD,  
IT MOST LIKELY  
IS.**



***UNACCEPTABLE SIDE WALL HEATER PLATE***



**FUSION PROCEDURE  
REQUIRES THE USE OF  
A PYROMETER**



**ALL HEATER PLATE TEMPERATURES MUST BE VERIFIED WITH AN  
EXTERNAL PYROMETER OF SOME KIND, THE DIAL GAUGES ON THE  
HEATER ARE NOT CONSIDERED ACCURATE.....**





## **FACTORY TEMP. GAUGES**

Not accurate, CAN NOT  
be used as verification of  
heater plate temperature.





## **DIRECT CONTACT PYROMETER**

Simple to use.

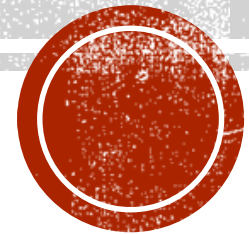


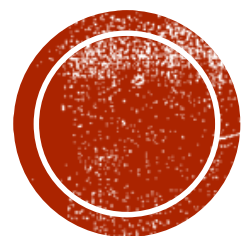
# LASER PYROMETER

- Must be able to demonstrate the proper  $\pm$  formula for the type of laser being used.
- The point and shoot method does not necessarily give a correct/ accurate reading.



# PIPE HANDLING PROCEDURES





**EVERY OPERATOR HAS SOME  
TYPE OF PIPE HANDLING  
PROCEDURE IN PLACE.**



## **FOLLOWING HANDLING PROCEDURES**

Pipe should be handled properly at ALL times.

This includes how it is stacked and stored on the job site.

ALL pipe manufacturers have guidelines on how pipe should be stored and handled.





**ROLLERS OR SOME  
TYPE OF BARRIER  
SHOULD BE USED  
TO AVOID DAMAGE  
TO PIPE IN  
DAMAGING  
ENVIRONMENTS**





**POWER POLE AND  
GUIDE ANCHOR  
PROBABLY SHOULD  
NOT BE USED AS A  
TURNING AID....**





## **PIPE SHOULD BE PROVIDED “ADEQUATE” PROTECTION**

If pipe is strung out and being pulled, it should be inspected to assure that it is not being damaged.





**NOT HANDLED  
PROPERLY WHEN  
TRANSPORTING  
OR  
WAS DAMAGED  
WHILE BEING  
PULLED ALONG  
ROW WITHOUT  
ROLLERS OR  
PROTECTION**





**NOT HANDLED  
PROPERLY WHEN  
TRANSPORTING  
OR  
WAS DAMAGED  
WHILE BEING  
PULLED ALONG  
ROW WITHOUT  
ROLLERS OR  
PROTECTION**





**NOT HANDLED  
PROPERLY WHEN  
TRANSPORTING  
OR  
WAS DAMAGED  
WHILE BEING  
PULLED ALONG  
ROW WITHOUT  
ROLLERS OR  
PROTECTION,  
NOT INSPECTED  
BEFORE FUSION  
EITHER !**





## **IMPROPER USE OF EQUIPMENT TO HANDLE PIPE**

Pipe appears to have  
been moved by use of  
bucket tooth.





# **IMPROPER USE OF EQUIPMENT TO HANDLE PIPE**

Pipe appears to have  
been moved by use of  
bucket





# **IMPROPER USE OF EQUIPMENT TO HANDLE PIPE**

Pipe appears to have  
been moved by  
excavator tracks





# **IMPROPER USE OF EQUIPMENT TO HANDLE PIPE**

Pipe appears to have  
been moved by  
excavator tracks





**UNACCEPTABLE**

Protect the Pipe in Some  
Way!





**UNACCEPTABLE**

Protect the Pipe in Some  
Way!





**SIGN POST CAUSED  
REMOVAL OF  
EXTERNAL BEAD**





**EXCAVATOR  
OPERATOR  
REFUSED TO  
LISTEN TO HIS  
DITCH MAN**





**EXCAVATOR  
OPERATOR  
REFUSED TO  
LISTEN TO HIS  
DITCH MAN**





**DID NOT WANT TO  
WASTE TIME  
“HAND DIGGING”**





**DID NOT WANT TO  
WASTE TIME  
“HAND DIGGING”**





**PROBABLY SHOULD  
HAVE USED STRAPS**





**PROBABLY SHOULD  
HAVE USED NYLON  
STRAPS INSTEAD OF  
MACHINE BUCKET**





**PROBABLY SHOULD  
HAVE USED NYLON  
STRAPS**





## **ON THE PIPE TRAILER READY TO BE FUSED TOGETHER**

Inspect the pipe prior to fusion and prior to installing in ditch or pulling into the bore.





# **CORRECT USE OF ROLLERS AND CRIBBING**





## **INCORRECT USE OF CRIBBING**





**MATTING DOES  
NOT MAKE IT  
BETTER**





**SERVICE LINE  
BORED UNDER  
STREET AND LEFT  
ON NEW HOME  
CONSTRUCTION  
SITE, UNPROTECTED**





**SERVICE LINE BORED UNDER  
STREET AND LEFT ON-SITE,  
UNPROTECTED**



# **FOLLOW PIPE HANDLING PROCEDURES**



*Manual*

# BOTTOM LINE

- Become familiar with the procedures put in place by the company you are working for.
- FOLLOW the procedures that have been put into place for use.





**192.321 (e).....tracer wire may not be wrapped around the pipe and contact with the pipe must be minimized but is not prohibited.....**



Make sure you adhere to the 18" rule on spotting located facilities. This 1" water tap was 1.5 inches outside of the small pothole that was used to spot the main.

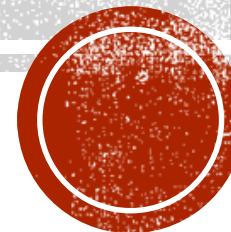


# WHEN WE PULL UP ON YOUR JOB SITE

- *Have a valid line locate number*
- *Be prepared to show proof of Qualification*
- *Be able to provide procedures for the task you are performing*
- *We will check your equipment for proper operation*
- *Be prepared to demonstrate proper execution of procedures*



**ANY QUESTIONS ?**



**RANDALL D. HAND  
TRAINING COORDINATOR  
ALABAMA PUBLIC SERVICE COMMISSION**

[Randall.Hand@psc.alabama.gov](mailto:Randall.Hand@psc.alabama.gov)

334-850-0044

